

Date: Tuesday, 8/21/2007 1:59:24 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG EXTRUSION
Job Number : 34125	
Estimate Number : 10326	
P.O. Number : <i>N/A</i>	Part Number : D27317
This Issue : 8/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2731 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 33420	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/10/2007 Qty: 100 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
-----	-------	---------------



Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s)
Lug Extrusion D2423
Batch: *B33310*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut D2423 extrusion to .82" Batch: _____

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



08/10/08/02
100

Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per folio D2731-7.
2-Check for crack while loading into the machine
3-Tumble
4-Deburr any rough edges after tumbling

Issue P.O 4439
Metec
Machine per drawing D2731 Rev B

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Review re-inspect for
fast damage

5.0	QC5	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Inspect levels

08/10/09/13

counter
4100

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 5/16/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 1:59:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 34125

Part Number: D27317

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(100)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR

07-09-14

7.0

POWDER COATING

POWDER COATING



M105086

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

MS 07-09-17

(100)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ES 07/09/18 (100)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ES 07/09/18 (100)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(100)

Comment: FINAL INSPECTION/W/O RELEASE

ND 07/09/19

Job Completion



W 07/09/19

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

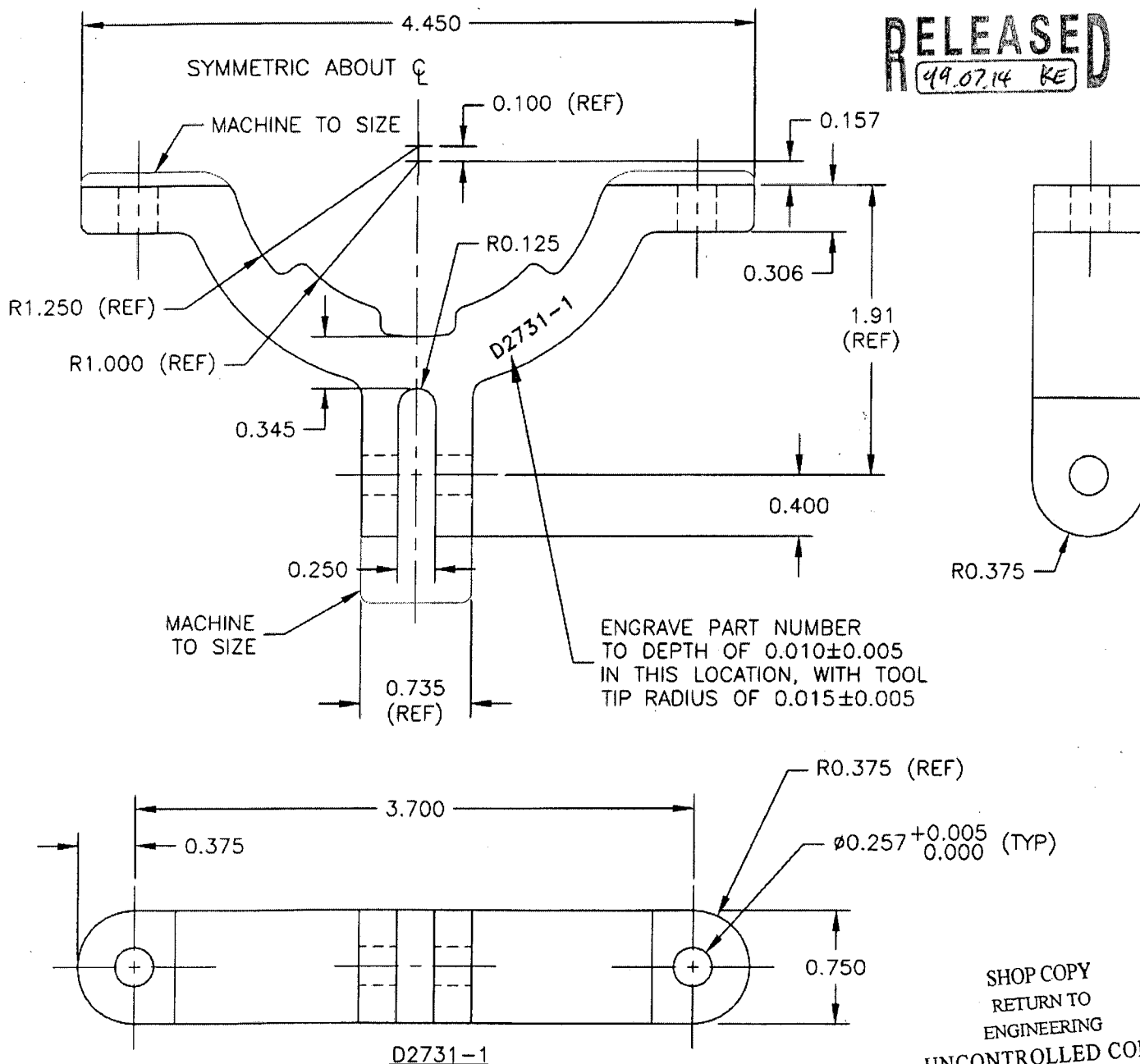
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



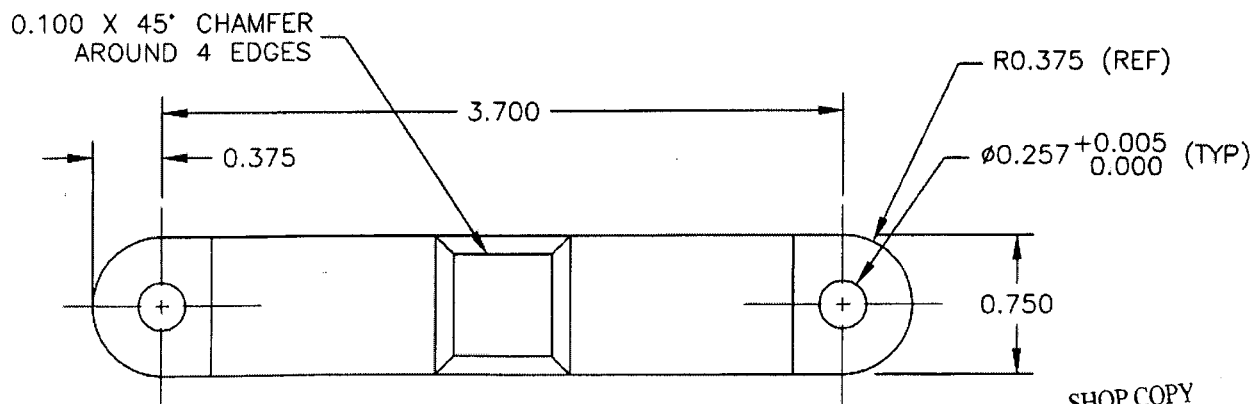
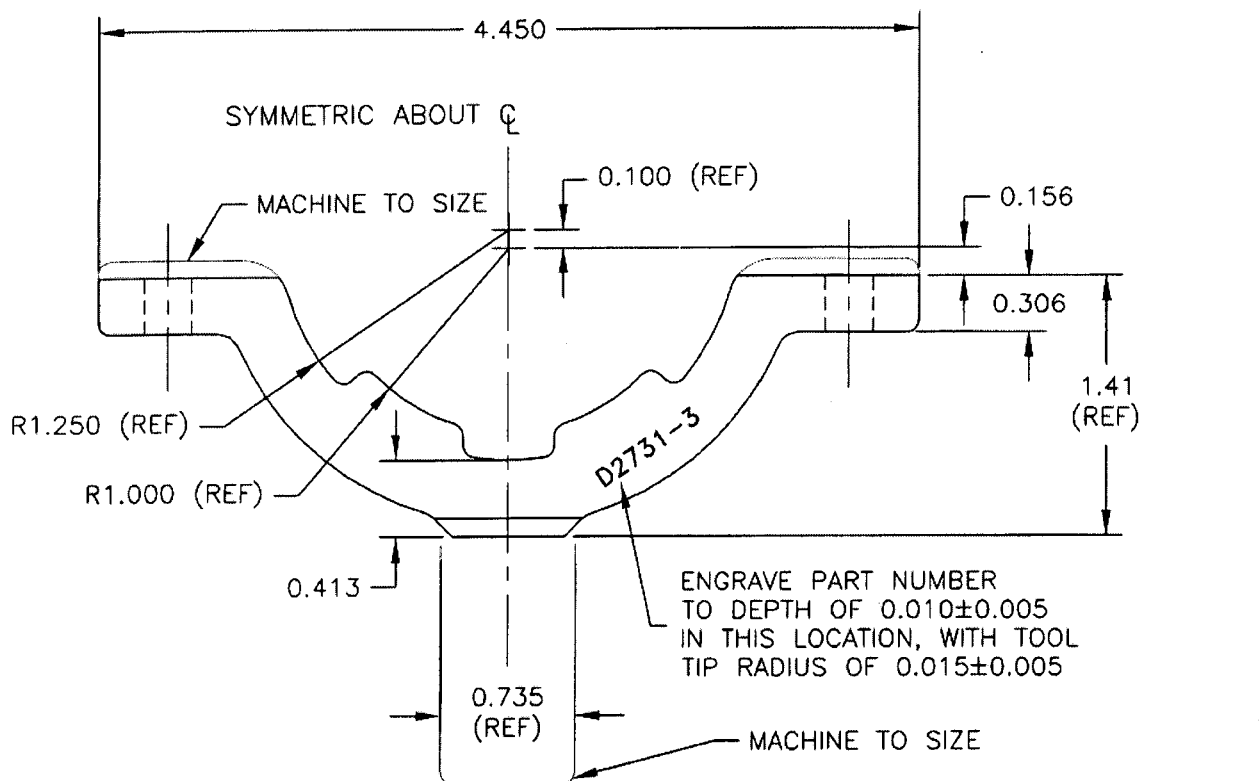
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34125



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CHECKED <i>KE</i>	APPROVED <i>Q</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
19.07.14 *KE*



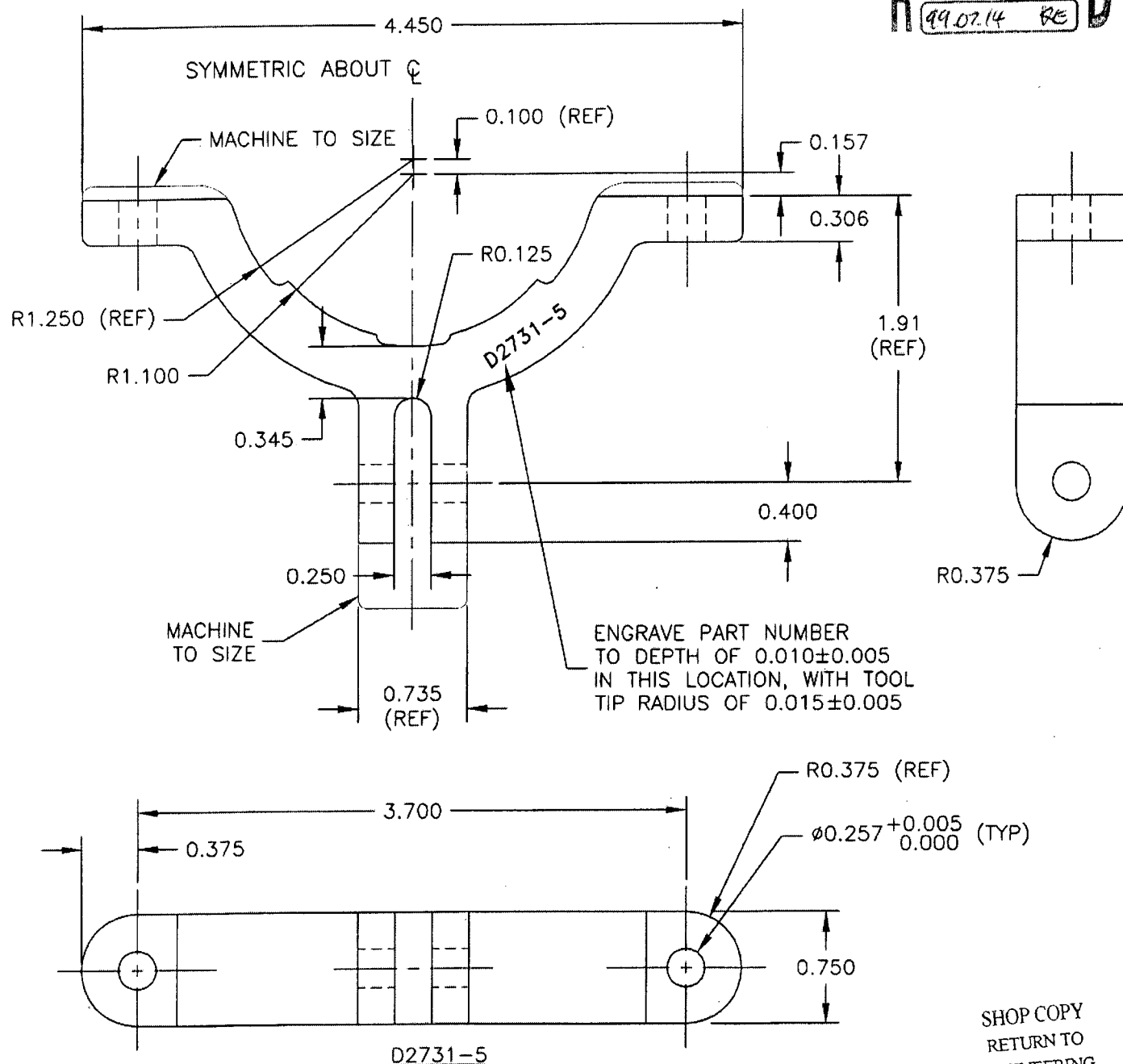
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DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 RE



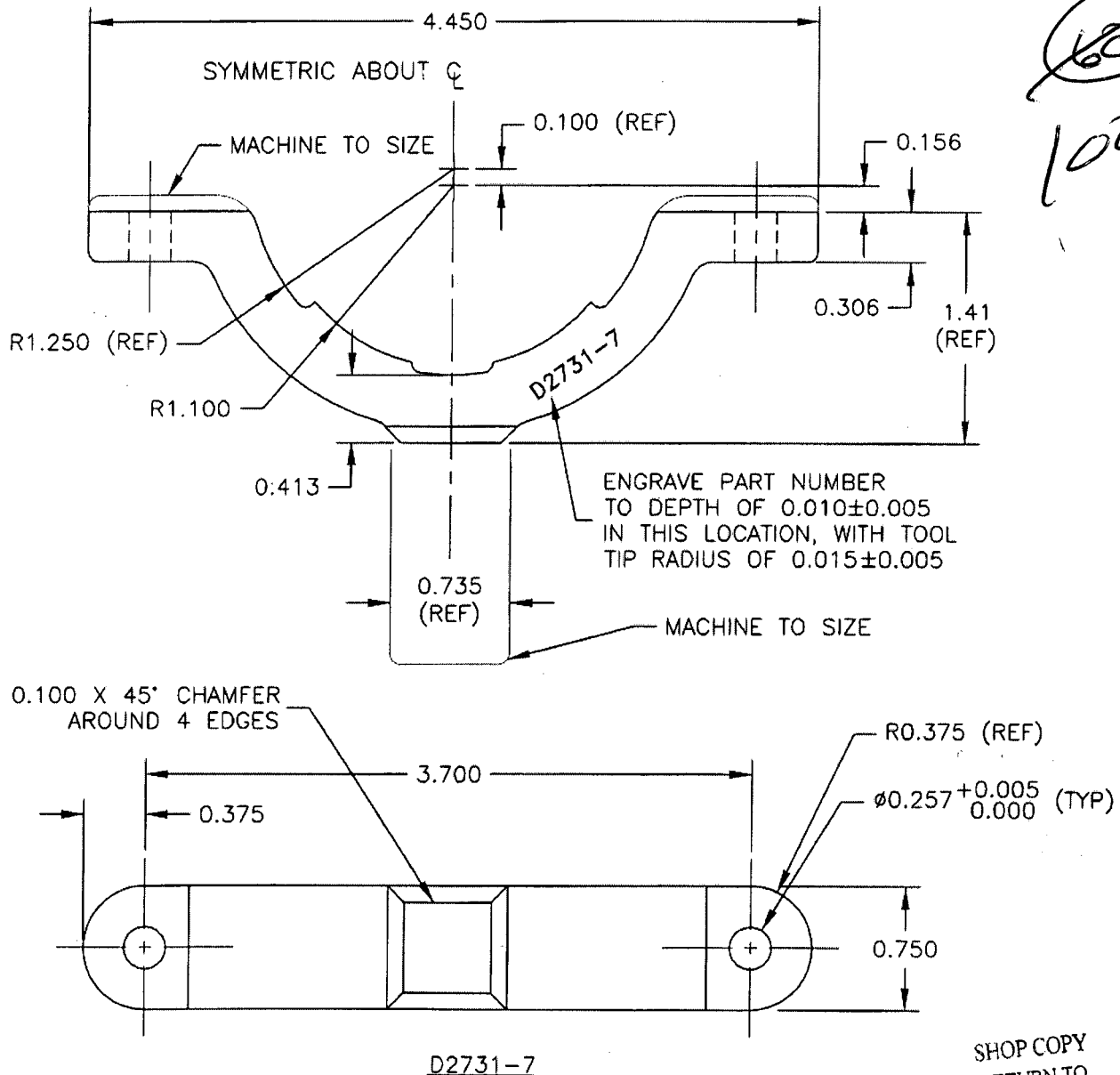
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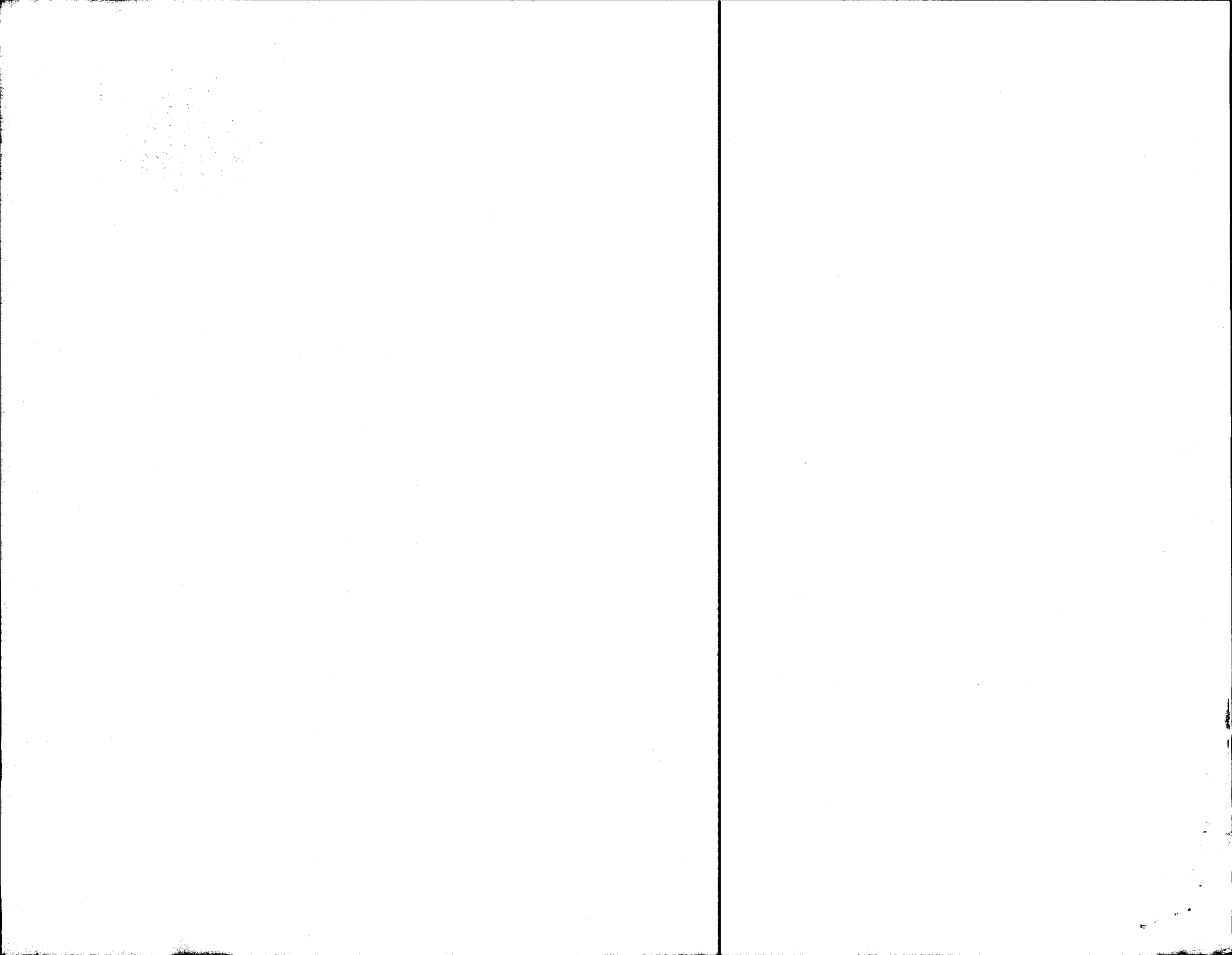
DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
99.07.14 *KE*



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
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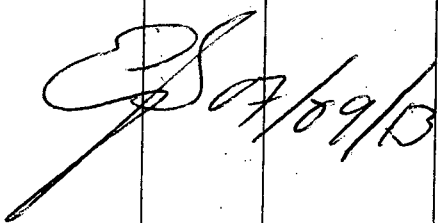




20 Terry Fox Drive
Vankeek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **16136**
Date: Sep 13, 2007
Page: 1

Sold to:		Ship to:	
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	
Order No.: 4439		Sold By:	
Shipped By: our truck		Ship Date: Sep 13, 2007	

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7	LUG MATERIAL SUPPLIED BY DART D2423 B#33310	Each	100	100	
					
Received by _____		Thank you for your order!			



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D2731-7	Lug	4439
MATERIAL: supplied by DART D2423 B33310			

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Denise Robinson", is written over a horizontal line.

Denise Robinson

Vankleek Hill, September 13, 2007